

Custom OK

SPHIT-1

DART AEROSPACE LTD	Work Order:	24244 B16414✓
Description: 206B Fwd Crosstube Assembly	Part Number:	D206-667-101
Dwg: D206-667-141 Rev. B	Qty:	3
		Page 1 of 3

Step	Location	Procedure	By	Date	Qty
1	DC ✓	Issue Traveler Dwg not required	U	05-09-12	3
2	DC ✓	Photocopy bluefile and create labels as per PPP D206-667-101 CHG002			
3	MS	Pick: Qty Part number Description Batch 1 D6001-105 Crosstube Check OD = 2.250"; ID = 1.874"			
4	MS	Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083			
5	MS	Turn first side as per Folio FA083			
6	MS	Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.			
7	QC1	Inspect dimensions as per Dwg D206-667-141			
8	MS	Turn second side as per Folio FA083			
9	MS	Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.			
10	QC1	Inspect dimensions as per Dwg D206-667-141			
11	QC8	Second inspection			
12	MS	Polish entire outside surface of crosstube			
13	MS	Remove sand and plugs			
14	MS	Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141			
15	FP	Chemical Conversion Coat as per QSI 005 4.1			
16	QC5	Inspect work to Step 15			
17	FP/LG	Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT. <i>Remove from stock</i>			
18	QC6	Inspect dimensions and work to Step 17 <i>buff cuffs to remove paint</i>			
19	LG	Drill pilot holes in tube as per Dwg D206-667-141 using drill Jig DT8541 & DT8542. Drill all (3) top holes.	DP	05-9-13	B
20	LG	Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.	DP	05-9-15	B
21	LG	Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.	DP	05-9-15	B
22	LG	Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.	DP	05-9-15	B
23	LG	Drill & ream the top (2) holes as per Dwg D206-667-141	DP	05-9-15	B

RELEASED
4/2/09/01

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Step	Location	Procedure	By	Date	Qty																												
24	LG	Drill rivet holes as per Dwg D206-667-141 using drill Jig DT8787FWD. Note: side with 3 x Ø0.323" holes is Fwd side.	DP	05-9-15	3																												
25	LG	Drill rivet holes as per Dwg D206-667-141 using drill Jig DT8787AFT.	DP	05-9-15	3																												
26	LG	C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.	DP	05-9-15	3																												
27	LG	Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141	DP	05-9-15	3																												
28	QC5	Inspect work to Step 27	Z	05-05-20	3																												
29	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	05-10-04	3																												
30	QC3	Inspect Chemical Conversion Coat	Z	05-10-04	3																												
31	PG	Liquid Penetrant Inspection as per QSI 038 Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order																															
32	RG	Inspect for transit damage Ensure copy of NDT results attached to work order.																															
33	QC6	Inspect for damage & ensure results are as per Dwg D206-667-141																															
34	FP	Prime inside and outside crosstube as per QSI 005 4.2	MM	05-10-04	3																												
35	FP	Paint outside crosstube with White Imron as per QSI 005 4.2	MM	05-10-04	3																												
36	QC14	Inspect Spray Paint	Z	06-01-11	4																												
37	FP	Wrap in plastic bag to protect from scratches	N/A																														
38	LG	Lug tube with the (3) hole side facing up. Pick: <table><tr><th>Qty</th><th>Part number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2856-400-694</td><td>Abrasion Strip</td><td>NA</td></tr><tr><td>2</td><td>D2873-043</td><td>Nut Plate</td><td>B24154</td></tr><tr><td>2</td><td>D2873-045</td><td>Nut Plate</td><td>B24155</td></tr><tr><td>2</td><td>D2891-1</td><td>Support</td><td>NA</td></tr><tr><td>14</td><td>MS20601AD4W8</td><td>Rivet</td><td>M18523</td></tr><tr><td>4</td><td>MS21920-20</td><td>Clamp</td><td>NA</td></tr></table>	Qty	Part number	Description	Batch	2	D2856-400-694	Abrasion Strip	NA	2	D2873-043	Nut Plate	B24154	2	D2873-045	Nut Plate	B24155	2	D2891-1	Support	NA	14	MS20601AD4W8	Rivet	M18523	4	MS21920-20	Clamp	NA	DP	06-1-6	3
Qty	Part number	Description	Batch																														
2	D2856-400-694	Abrasion Strip	NA																														
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2	D2891-1	Support	NA																														
14	MS20601AD4W8	Rivet	M18523																														
4	MS21920-20	Clamp	NA																														
39	LG	Install abrasion strips as per QSI 035 using DT8579 (3) top holes should be facing up.	N/A																														
40	LG	Install supports and clamps as per Dwg D206-667-141. Torque clamps to 80-100 in lb.	N/A																														
41	LG	Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.	DP	06-1-6	3																												
42	QC5	Inspect work to Step 41	Z																														

check last page

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2/1/05-01-01

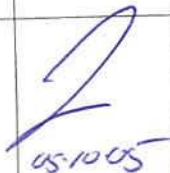
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Step	Location	Procedure	By	Date	Qty																
43	KP	<div>Pick: Packing Kit</div> <table><thead><tr><th>Qty</th><th>Part number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>10</td><td>AN5-7A</td><td>Bolt</td><td>m17944</td></tr><tr><td>4</td><td>AN5-30A</td><td>Bolt</td><td>m18079</td></tr><tr><td>10</td><td>AN960JD516</td><td>Washer</td><td>8x m 10765 / 2x m 18254</td></tr></tbody></table>	Qty	Part number	Description	Batch	10	AN5-7A	Bolt	m17944	4	AN5-30A	Bolt	m18079	10	AN960JD516	Washer	8x m 10765 / 2x m 18254			
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10	AN5-7A	Bolt	m17944																		
4	AN5-30A	Bolt	m18079																		
10	AN960JD516	Washer	8x m 10765 / 2x m 18254																		
44	QC4	Inspect Kit 100% for Completeness on the W/O	CL	06/01/11	1																
45	PK	Identify and pack for shipping as per PPP D206-667-101 REV. C	SP	06/01/11	1																
46	AC	Cost / part: _____	CL	06/01/11	1																
47	DC	Close W/O Inspect Level 21																			

Rev	Date	Change	Revised By	Approved
A	00.11.21	New Issue	EC	
B	01.02.06	Combined 667-141 with 667-101	EC	
C	01.08.08	Reformat	SM	
D	01.10.01	Added tool #'s & Imron paint	SM	
E	04.02.16	Reformat	KJ/DS	
F	05.08.30	Add holes for compatibility with Bell Skidtubes	KJ/JLM	

RELEASED
2/1/05 9:01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-05	35	cuffs reworked & re-painted. grinder marks show on x-tubes also little knicks.		re-paint x-tubes Imron white as per QS 1005 4.2 too supports on both sides				 05-10-05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____